

Work Order ID 113157

February-25-14 10:53:47 AM

113157

Page 1

Item ID: D4021-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hoop
 Start Date: 2/10/14 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 2/10/14 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-02-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4021	B

100 0.00

100

Waterjet
FLOW CNC Waterjet

Memo
Cut as per dwg D4021
Prog Rev: B
Dwg Rev: B

Deburr as required

110 0.00

110

QC
Quality Control

Memo

16 0 Ac
02-27-14

16 0 Ac
02-27-14

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00 DAS 27 9-19 14/2/27				16			
130 *130* Small Fab Small Fab	Memo 1- make radius as per dwg 2- deburr	0.00 0.00				16x		CC 14-4-1	
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				16x		14.4.4	DAS 24 9-88

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Item ID: D4021-7 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Hoop

Start Date: 2/10/14 Start Qty: 16.00 *16*

Required Date: 2/10/14 Req'd Qty: 16.00 *16*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>W1004</u>	0.00				<u>16*</u>		<u>14.4.4</u>	DAS 24 9-89
150	Packaging Memo	0.00							
	Packaging								
160	QC21- Final Inspection - Work Order Release	0.00						<u>R 14-4-4</u>	
160	QC Memo	0.00							
	Quality Control								

R 14-04-4

Picklist Print

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Work Order ID: 113157

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Parent Item: D4021-7

D4021-7

Parent Item Name: Hoop

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.625X3.000 Purchased No

100 f

16.0000

0.4166

8

M304B0 625X3 000

**

Jm14-02-26

304 BAR .625 X 3.00

Location

Loc Qty

Loc Code

MAT049

16

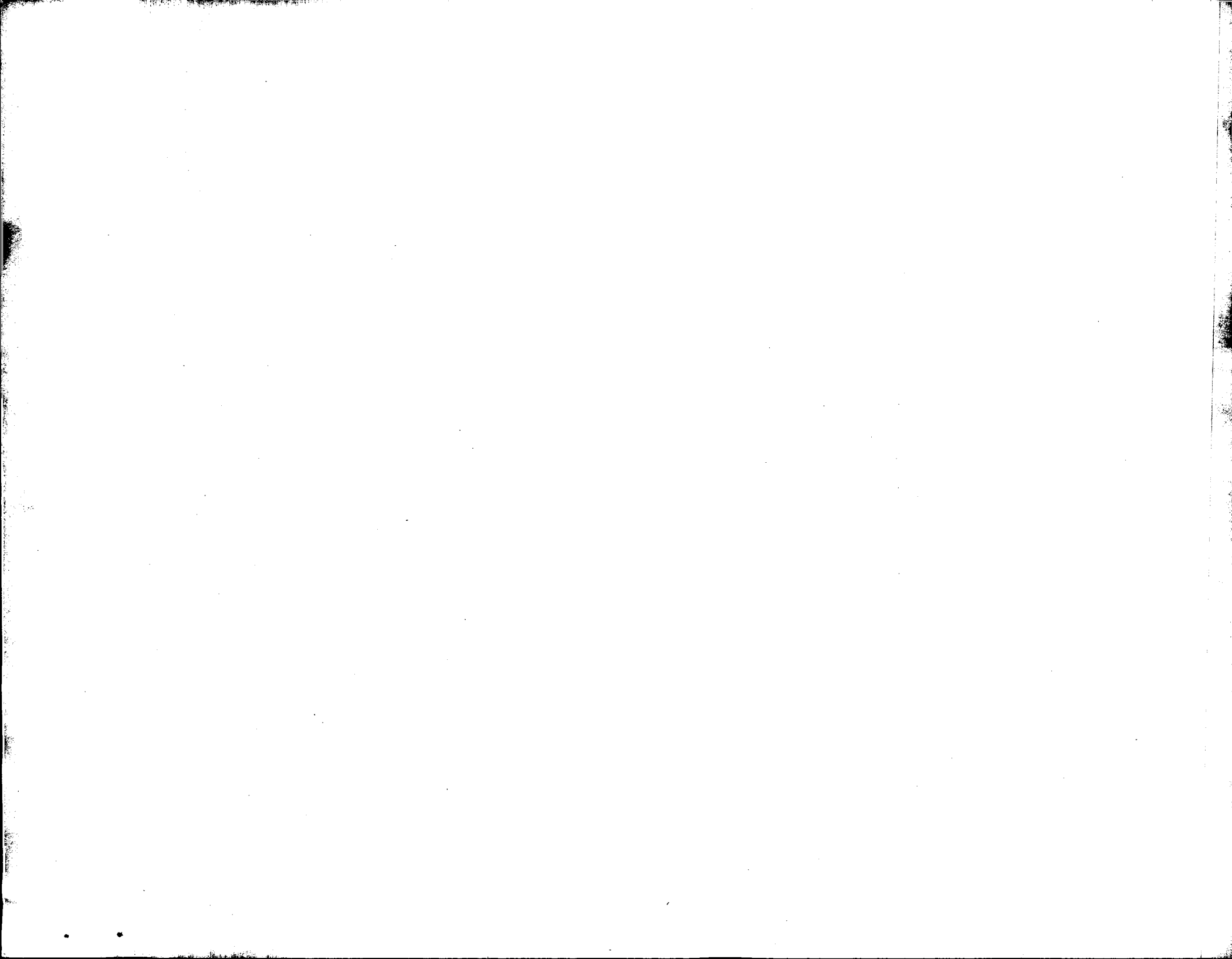
m127015

6

m127612

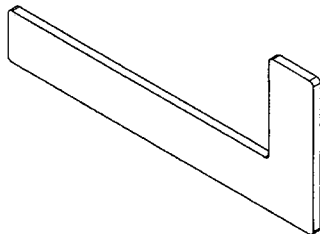
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127612

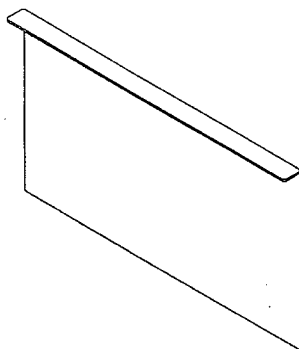


FIRST ARTICLE INSPECTION CHECKLIST

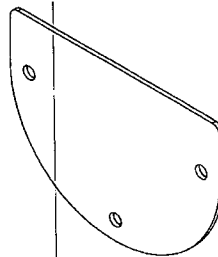
Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.08.18	Dimensions revised per Dwg Rev B	KJ	



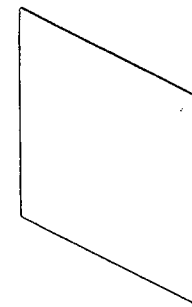
D4021-1 HANDLE PLATE



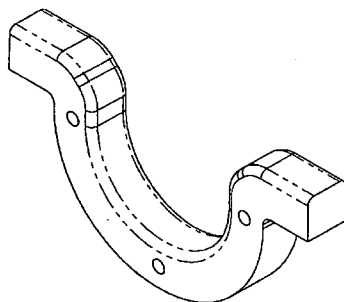
D4021-3 DATA PLATE



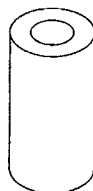
D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP

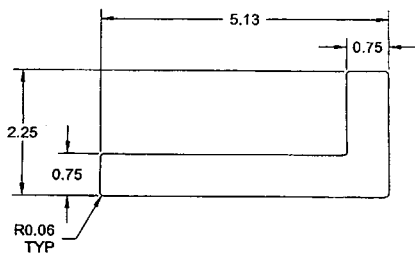


D4021-9 BUSHING

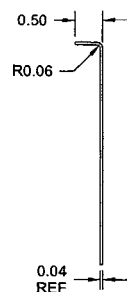
113157 MJS
14-02-14

RELEASED
2010-04-14
MJP

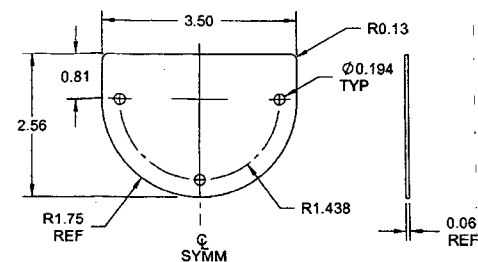
B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	



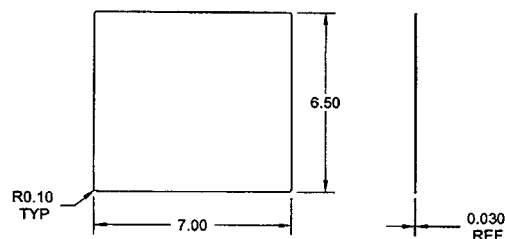
D4021-1 HANDLE PLATE



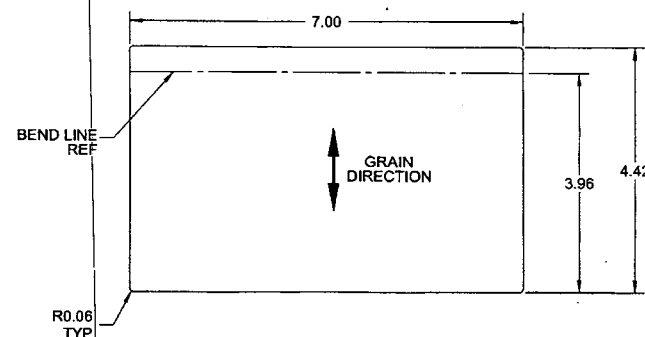
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
R 2010-04-14
ND

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

2) FINISH: -1/-3/-11: NONE

-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX



6) IDENTIFICATION: N/A

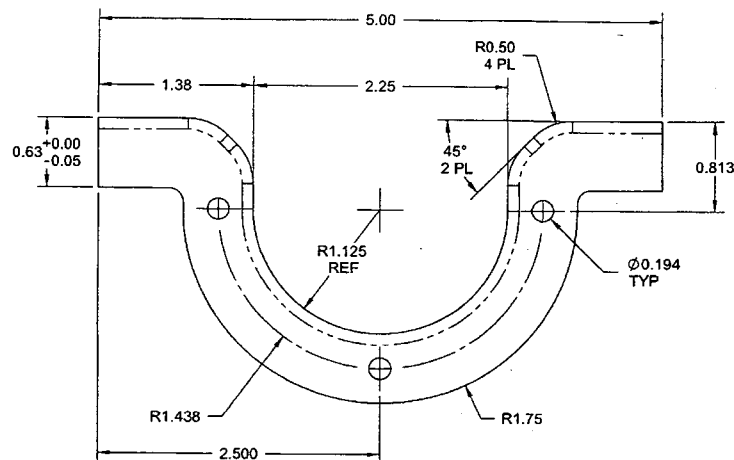
7) WEIGHT -1: 0.18 lbs

-3: 0.35 lbs

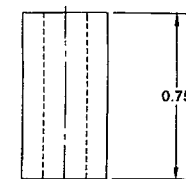
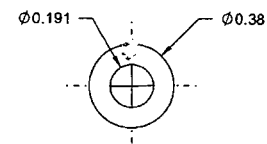
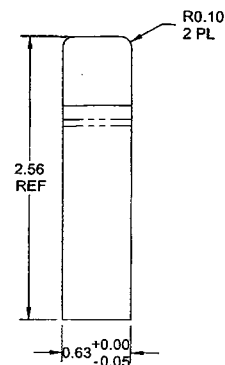
-5: 0.14 lbs

-11: 0.39 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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D4021-7 HOOP



D4021-9 BUSHING

NOTES:

1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT -7: 0.80 lbs

-9: 0.02 lbs

RELEASED
2010-04-14
NRP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4021	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MISC PARTS - 350 BASKET	NTS
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